

Work Order ID 133756 -1

Wednesday, June 17, 2015 9:26:00 AM

133756

Page 1

Item ID: D350-591-113

Revision ID:

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15 Start Qty: 10.00

Required Date: 7/03/15 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2310	D
DSI 9525	A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-591-113

CHG005

DAS
6
9-89

JUL 03 2015

110

Large Fab

0.00

110

Large Fab

Memo

0.05

Large Fab

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
3-Debur

10X DL 15/6/17

Work Order ID 133756

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133756

Page 2

Item ID: D350-591-113

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

10

JUN 22 2015

DAS
24
9-89

123

0.00

123

Mill Conv

Memo

0.00

Conventional Milling Machine

OPEN HOLE FOR BUSHING TO SIZE AS PER DWG AND C'SINK.

10

Ø

J.C.-L, 19/06/24

126

QC5- Inspect part completeness to step on W/O

0.00

126

QC

Memo

0.00

Quality Control

10x

DAS
43
9-89

JUN 29 2015

Work Order ID 133756

Wednesday, June 17, 2015 9:26:00 AM

133756

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Item ID: D350-591-113

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Large Fab	0.00							
130									
Large Fab	Memo	0.05							
Large Fab	1-Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: <u>B130855</u> 2-Grind end cap and bottom bushing welds flush 3-Machine top weld on bushing flush								
	STEP 132 → MILL CONV RP 15/07/02								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

10x 66 15-7-2

10 JUL 02 2015 DAS 24 9-89

10 JUL 02 2015 DAS 24 9-89

Wednesday, June 17, 2015 9:26:00 AM

Item ID: D350-591-113

Revision ID:

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15 : **Start Qty:** 10.00

Required Date: 7/03/15 **Req'd Qty:** 10.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.05

Hand Finishing

170

Large Fab

0.00

170

Large Fab

Memo

0.05

Large Fab

1-Rivet as per Dwg D2310

2-Inspect for foreign object as per QSI 024

3-Weld Aft end cap as per Dwg D2310

A/R AL ROD Batch: 8130855

4-Grind end cap welds flush

180

QC10- Inspect visual per QSI004- ground welds

0.00

180

OC

Memo

0.00

Quality Control

⑩ ϕ 02/07/02

5x CC 15-7-2

5 JUL 02 2015

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Item ID: D350-591-113

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15 Start Qty: 10.00

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Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							DAS 24 9-89
190						5	JUL 02 2015		
QC	Memo	0.00							
Quality Control									
200	Chemical Conversion Coat per QSI005 4.1	0.00							DAS 34 9-89
200						5	15-7-2		
HandFinish	Memo	0.02							
Hand Finishing									
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							DAS 34 9-89
210						5	15-7-3		
Powdercoat	Memo	0.02							
Powder Coating									
	START TIME: 8:25								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 8:55								

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Item ID: D350-591-113

Accept

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Setup Start *NS1*

Revision ID:

Item Name: Heli-Access Step, Short, High Gear

Stop *NS2*

Start Date: 6/18/15 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Wing Walk as per dwg QSI005 4.4 Batch 11325800	0.00							
220	HandFinish	0.03							
Hand Finishing	Memo								
230	QC3- Inspect Part Finish	0.00							
230	QC	0.00							
Quality Control	Memo								
240	Pick Kit	0.00							
240	Packaging	0.00							
Packaging	Memo								

5x of 11325800

⑤ DAS 38 0-89 SP
JUL 03 2015

5x SP 15-07-03

Work Order ID 133756

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Item ID: D350-591-113

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/03/15 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	QC4- 100% Inspect kits for completeness	0.00							
250									
QC	Memo	0.00							
Quality Control									
260		0.00							
260									
Packaging	PACKAGING RESOURCE #1	0.00							
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D350-591-113								
	Location: _____								
270	QC21- Final Inspection - Work Order Release	0.00							
270									
QC	Memo	0.02							
Quality Control									

JUL 03 2015

DAS
6
9-89

JUL 03 2015

JUL 03 2015

Picklist Print

Wednesday, June 17, 2015 9:26:05 AM

Page 1

Work Order ID: 133756

133756

Parent Item: D350-591-113

D350-591-113

Parent Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15

Required Date: 7/03/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:H04.11.09ReformatKJ/JLM
ECN10-586 10.06.18 DD verf:EC

IPP Rev:E as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116		Manufactured	No			110	Each	143.3200	1	10			
-----------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

D2244-116

STEP EXTRUSION

CC JUL 02 2015

Location	Loc Qty	Loc Code
HALL	138	
117818	138	
WA003	5.3199632	
104940	5.32	

D2275		Manufactured	No			130	Each	33.0000	1	10			
-------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2275

Bushing

CC JUL 02 2015

Location	Loc Qty	Loc Code
WA003	33	
103631	13	
108945	20	

D2673-34		Manufactured	No			130	Each	29.0000	2	20			
----------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2673-34

End Plate

CC JUL 02 2015

Location	Loc Qty	Loc Code
WA003	29	
128133	19	
133494	10	

20x

Picklist Print

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Work Order ID: 133756

133756

Parent Item: D350-591-113

D350-591-113

Parent Item Name: Heli-Access Step, Short, High Gear

Start Date: 6/18/15

Required Date: 7/03/15

Start Qty: 10.00

Required Qty: 10.00

D2582 Manufactured No 170 Each 10.0000 1 10

D2582

Hi-Skid Step Leg Ass'Y

**

11 15-7-2

Location

Loc Qty

Loc Code

WA003

10 B

127837

1

128853

4

130259

2

133125

3

1x

4x

2x

3x

MS20600-AD4W3

Purchased

No

170 Each

473.0000

16

160

MS20600-AD4W3

Cherry Rivets

**

11 15-7-2

Location

Loc Qty

Loc Code

GA

389

m129795

389

WA003

84

m130018

84

67x

123x

K591-113

Manufactured

No

240 Each

0.0000

1

10

K591-113

Short Step Instln

**

B1338608p
150703

DAS
6
9-89

Wednesday, June 17, 2015 9:26:06 AM

Shop Packet Print

Page 2



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

DS-6-15
133756

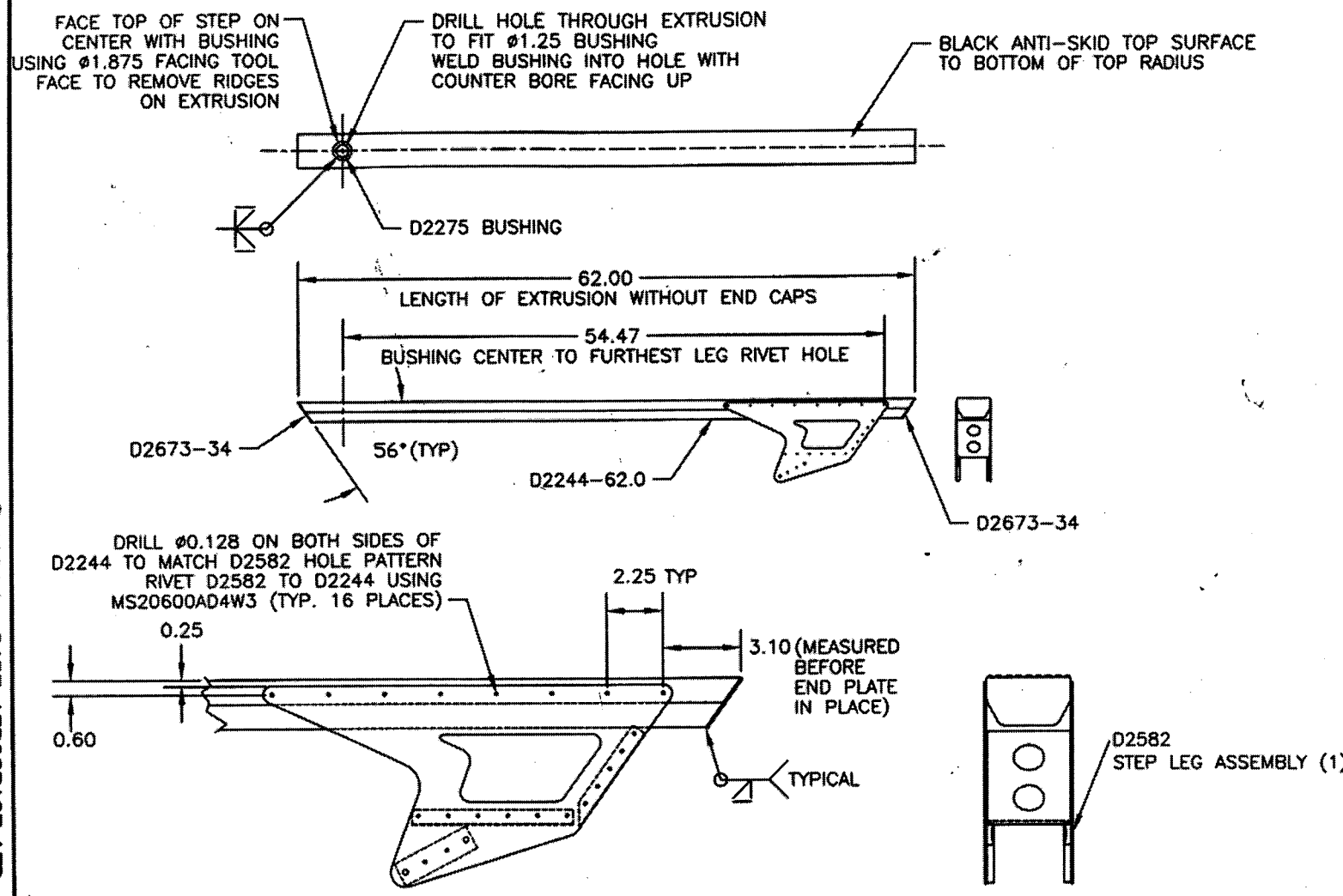
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05.11.28

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CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2310	REV. D
		TITLE	HIGH SHORT STEP ASSEMBLY	SHEET 2 OF 2
		SCALE	NTS	



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 Heli-Access-Step™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171	CLAMP
4	2	2	2	2	D2182B035	CUSHION
8	4	4	4	4	D2274	RADIUS BLOCK
			1		D2362-041	SUPPORT BRACKET
2	1			1	D2362-3	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A	BOLT
4	4	4		4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

THE DSI-9525-XXX KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				DSI-9525-011	STEP CUSHION KIT (FOR D350-591-111A)
	X			DSI-9525-013	STEP CUSHION KIT (FOR D350-591-113/-119)
		X		DSI-9525-015	STEP CUSHION KIT (FOR D350-591-115)
			X	DSI-9525-017	STEP CUSHION KIT (FOR D350-591-117A)
2	1	1	1	D3595-200-300	CUSHION
		4		AN4-20A	BOLT
8	4			AN4-21A	BOLT
			4	AN4-22A	BOLT
8	4	4	4	NAS1149D0463J	WASHER (OR AN960JD416)
8	4	4	4	MS21042L4	NUT

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:

THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

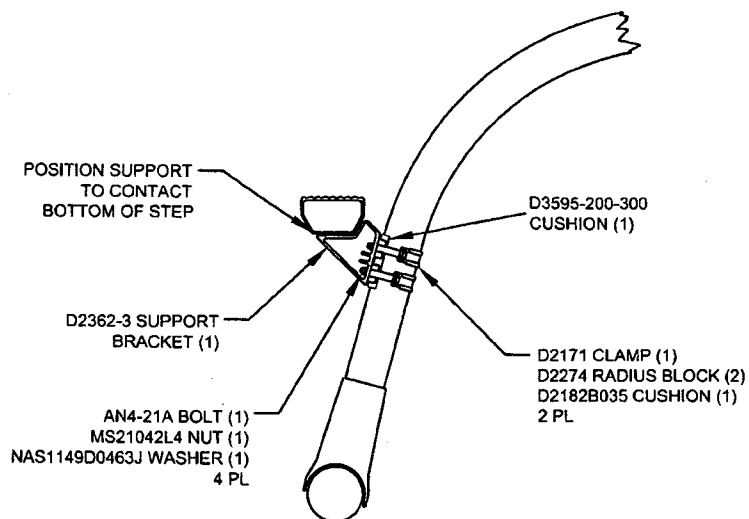
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08

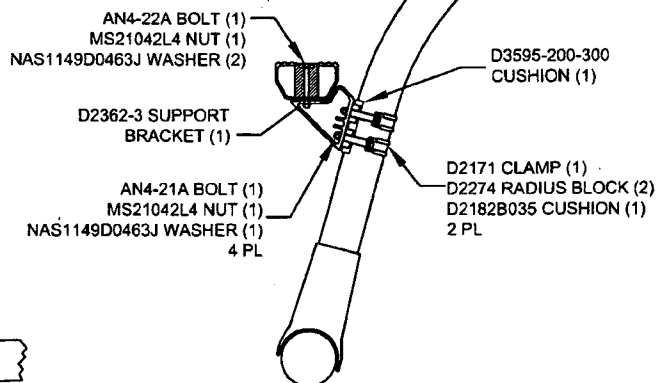
CERT. NO.: SH92-6

ISSUE NO.: 11

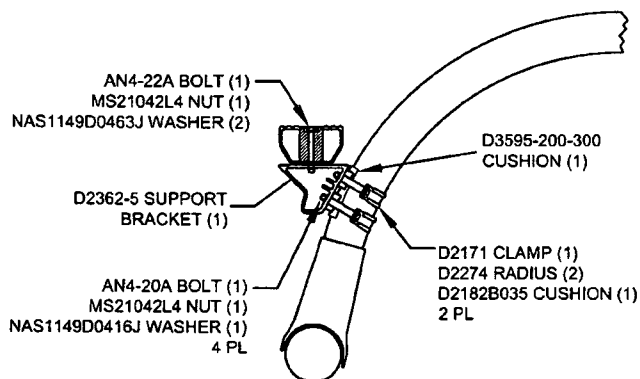
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DRAWN	8	
CHECKED	1	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9525 SHEET 2 OF 4
APPROVED	10	TITLE SCALE
DE APPR.	TH	STEP CUSHION CHANGE NTS
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SECTION C-C: CENTER SUPPORT
(D350-591-111A ONLY)
(NOT TO SCALE)



SECTION D-D: AFT ATTACHMENT
(D350-591-111A/-113/-119 ONLY)
(NOT TO SCALE)



SECTION E-E: AFT ATTACHMENT
(D350-591-115 ONLY)
(NOT TO SCALE)

FIGURE 32-9: Crosstube Attachment
REF ICA-D350-591

FIGURE 9: Crosstube Attachment
REF D350-591

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>[Signature]</i>	D. SHEPHERD (DE # 02)
DATE: 10.06.08	
CERT. NO.: SH92-6	
ISSUE NO.: 11	

DESIGN	<i>90</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP CUSHION CHANGE	NTS
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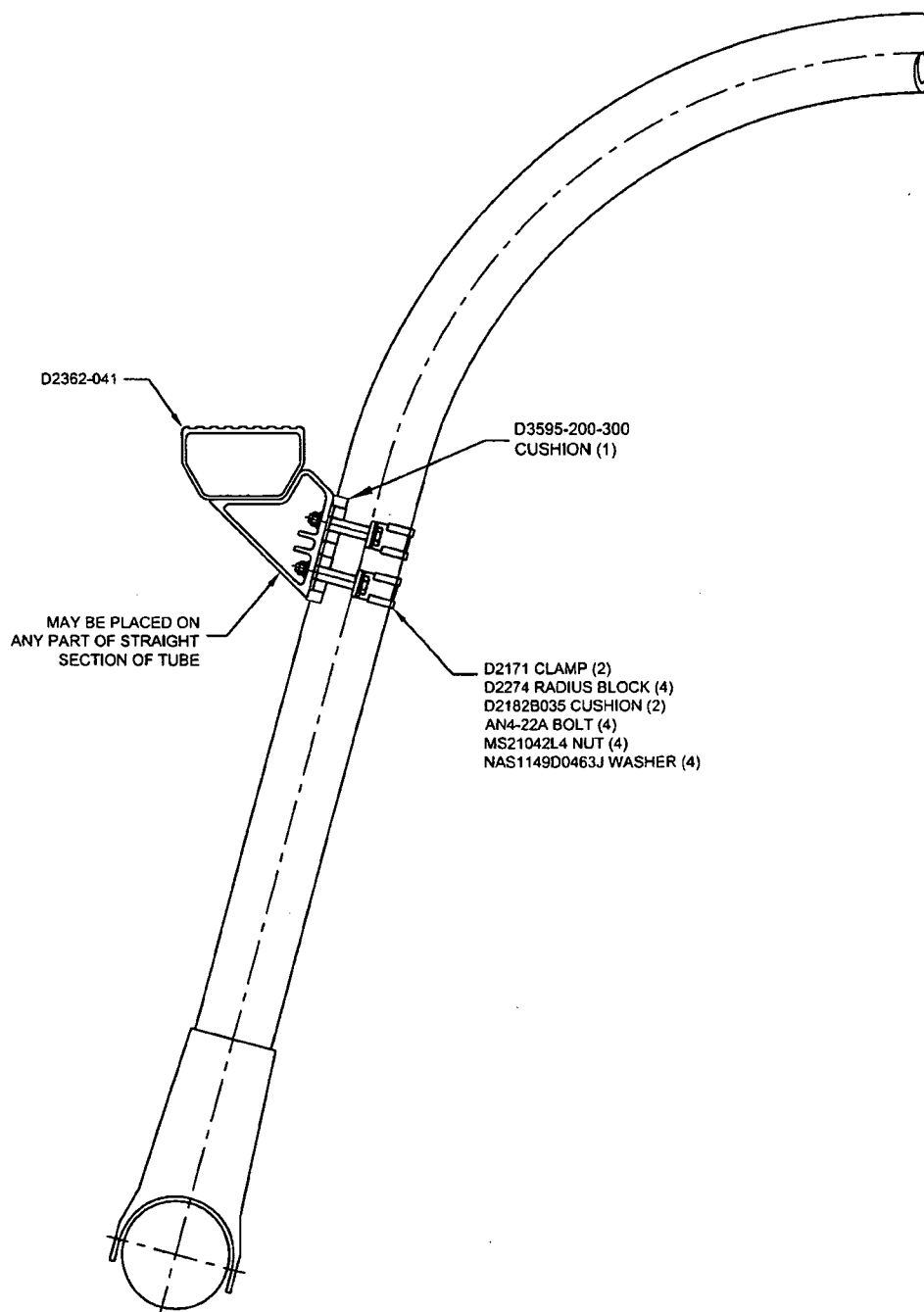


FIGURE 32-10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF ICA-D350-591

FIGURE 10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF D350-591

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<u>90</u>	DART AEROSPACE LTD	
DRAWN	<u>JS</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>JS</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 4 OF 4
APPROVED	<u>JS</u>	TITLE	SCALE
DE APPR.	<u>JS</u>	STEP CUSHION CHANGE	NTS
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